

Date: Tuesday, 10/02/2009 3:09:43 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE ASSEMBLY LOWER DOOR
Job Number : 45727	
Estimate Number : 13562	
P.O. Number :	Part Number : D3813041
This Issue : 10/02/2009 S.O. No. :	Drawing Number : D3813 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 42050	Material :
Written By :	Due Date : 28/02/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 09-02-10</u>	
Comment : Est Rev:A New Issue 08-09-09 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D38131	Hinge, Upper Door
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Hinge, Upper Door

Batch: B45795

FF 09-04-21 (6)

2.0	D35183	Stainless Steel Ball Joint Rod End
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Stainless Steel Ball Joint Rod End

Batch: B45822

FF 09-04-21 (6)

3.0	NAS5096	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

BATCH: M109249

FF 09-04-21 (6)

4.0	MS124738	Heli-Coil 3/8-24 unf
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Heli-Coil 3/8-24 unf

BATCH: M109249

FF 09-04-21 (6)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install helicoils as per Dwg D3813

2-Install Ball joint and nut loosely as per Dwg D3813

FF 09-04-21 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:09:43 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE ASSEMBLY LOWER DOOR

Job Number: 45727

Part Number: D3813041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/21 (x6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 139C

1' 9/4/21

(62)

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 (x1)

Job Completion



09-04-21

Dart Aerospace Ltd

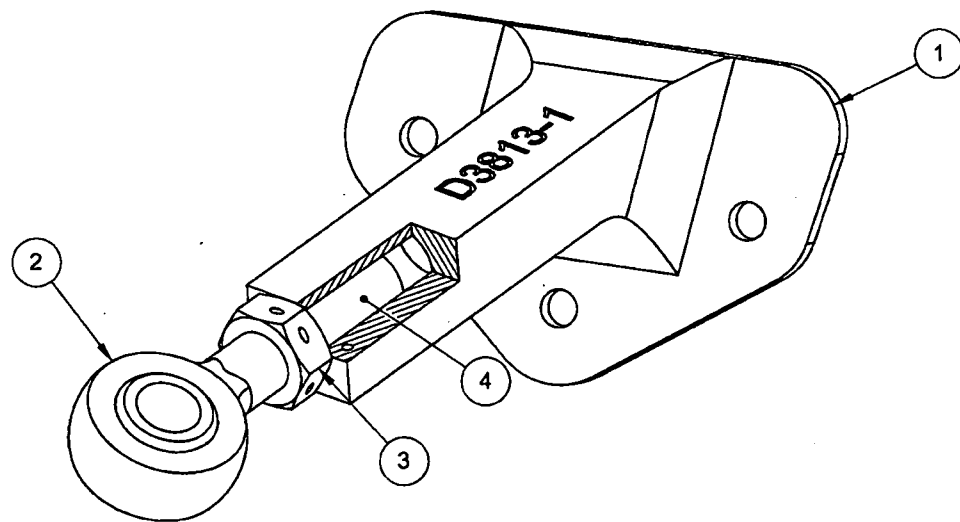
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

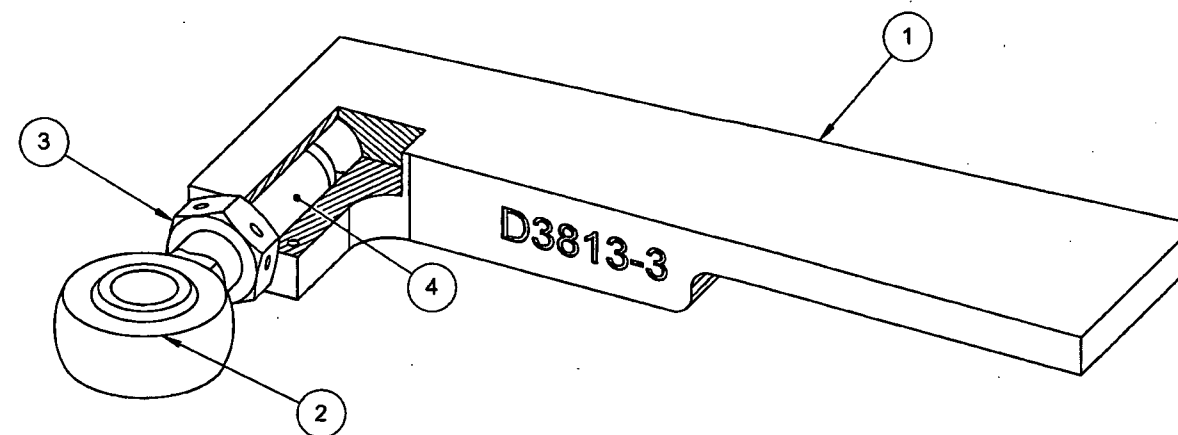
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3813-1	HINGE, UPPER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-041 HINGE ASSY, UPPER DOOR



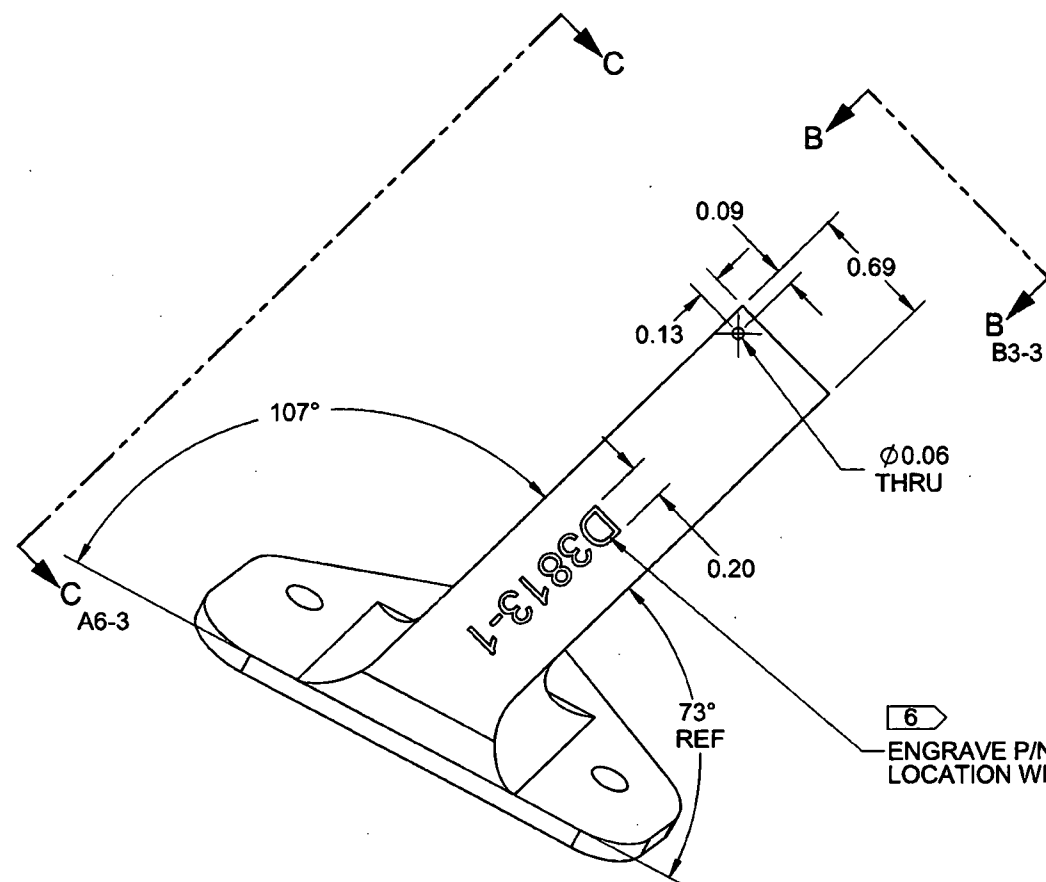
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1	D3813-3	HINGE, LOWER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-043 HINGE ASSY, LOWER DOOR

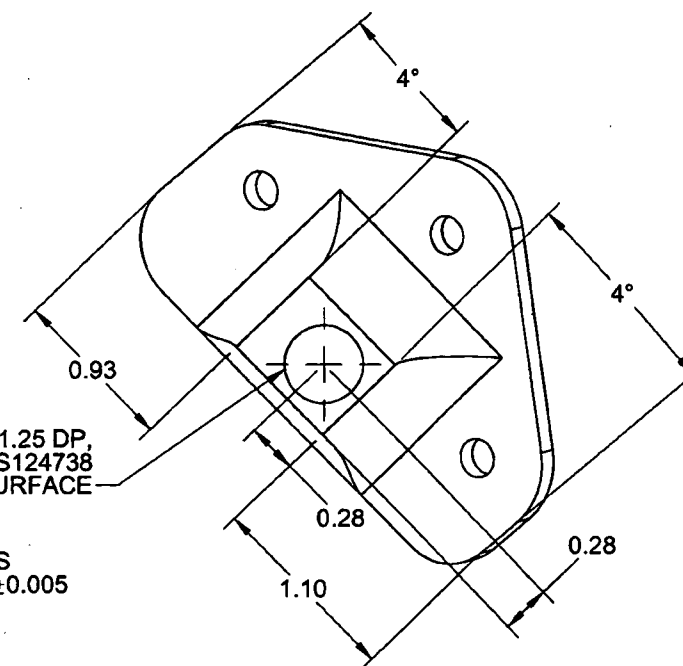
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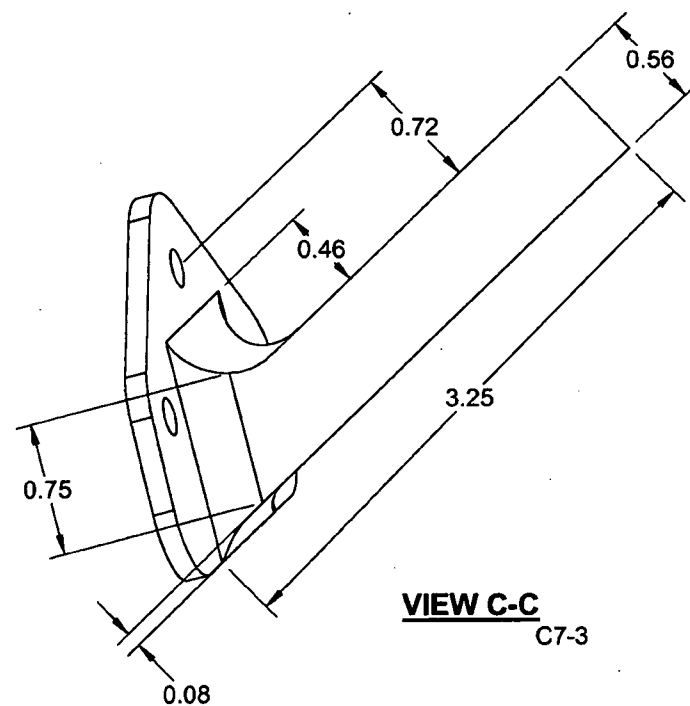
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REV.	DESCRIPTION	BY	DATE
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MFG. APPR.			
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DATE	08.11.10		
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VIEW A-A
C4-2



VIEW B-B
D5-3



VIEW C-C
C7-3

Ø0.391 X 1.25 DP,
INSTALL HELICOIL MS124738
FLUSH WITH SURFACE

6
ENGRAVE P/N TO DEPTH OF 0.005 IN THIS
LOCATION WITH TOOL TIP RAD OF 0.015±0.005

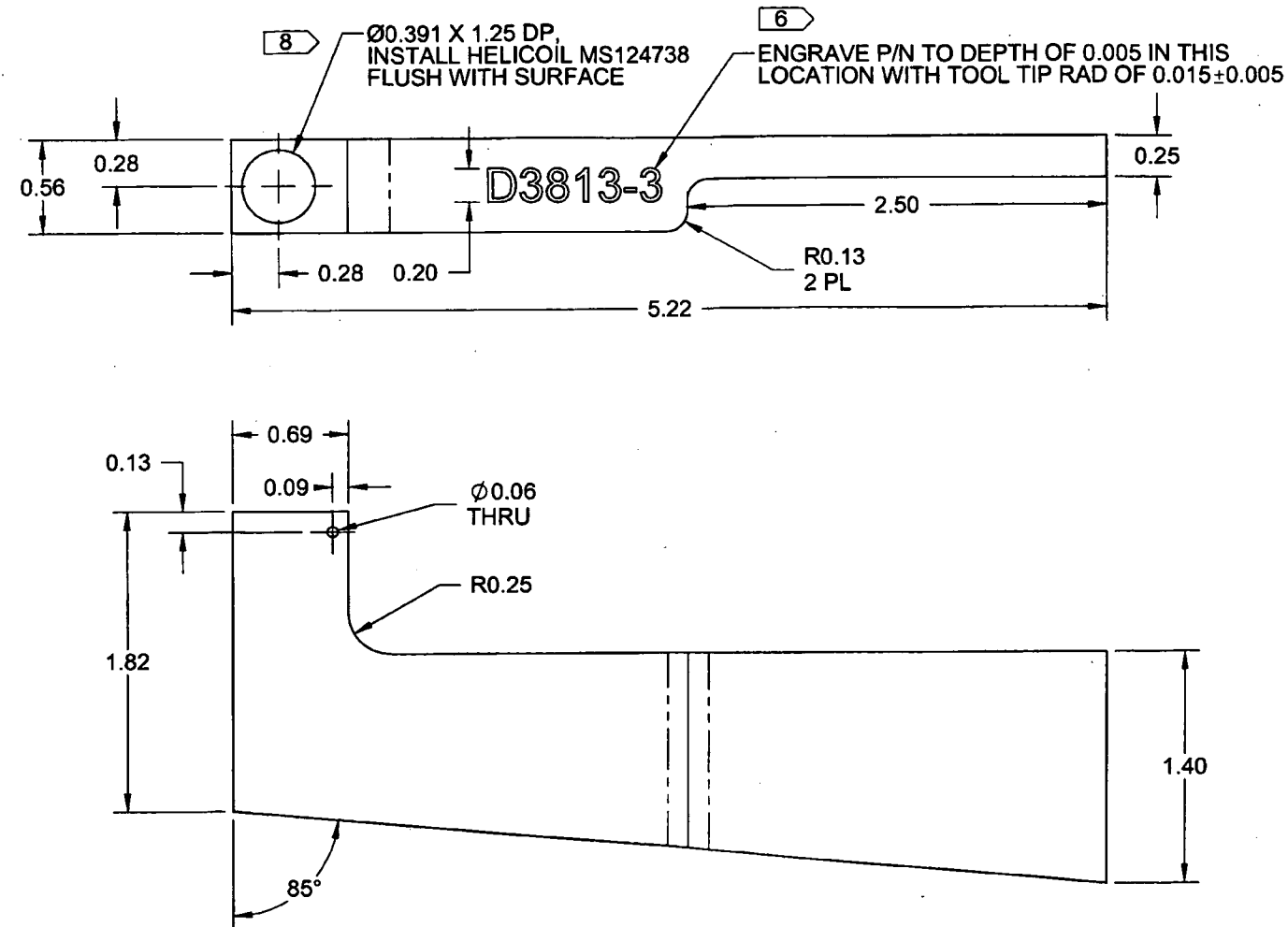
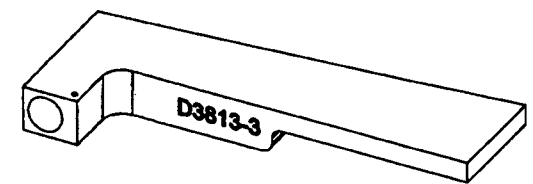
D3813-1 HINGE, UPPER DOOR

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WORK ORDER
NO. 45727

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D3813-3 HINGE, LOWER DOOR

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09/07/13 MMS 127

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.24 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

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